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 [73] Assignee **Chase Bag Company**  
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**Dec. 23, 1969. Divided and this application**  
**Apr. 23, 1969, Ser. No. 828,061**

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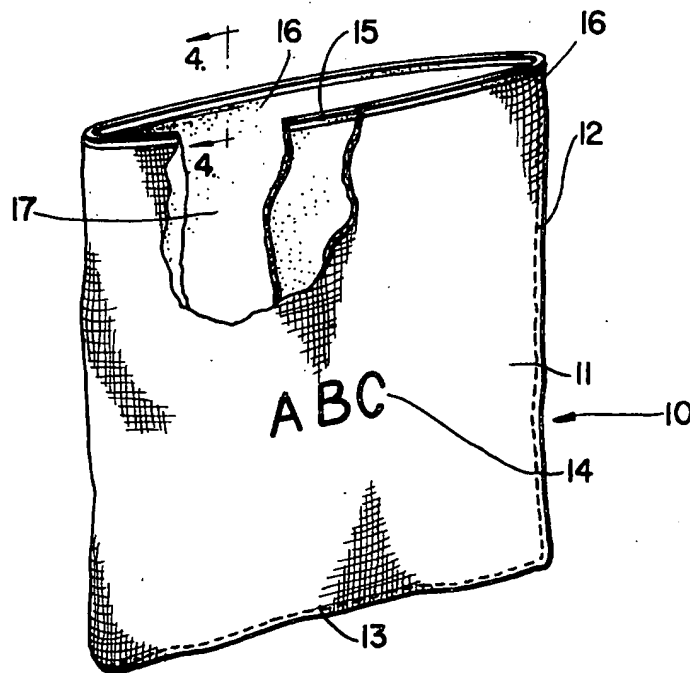
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[54] **METHOD OF MAKING PLASTIC-LINED BURLAP BAG**  
**5 Claims, 4 Drawing Figs.**

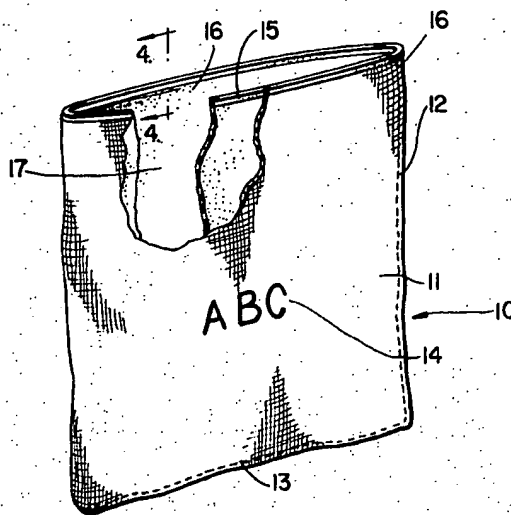
[52] U.S. CL..... **156/93**  
 [51] Int. CL..... **B32b 31/04**  
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**283, 93, 320, 70; 112/10; 223/39, 40; 2/164; 93/8**  
**WA; 229/17 G**

**ABSTRACT:** A burlap bag having a polyethylene plastic liner which is secured only at the mouth of the bag by a single line of thermoplastic adhesive which may be reactivated, positioned about the interior edge of the mouth, with the seams of the bag on the inside, the steps of manufacture including first extruding a line of adhesive onto one edge of the burlap, forming the bag in conventional manner, turning the bag, which is formed "wrong" side out, turning and inserting the liner, and reactivating the adhesive to secure the liner at the inside edge of the mouth of the bag only.

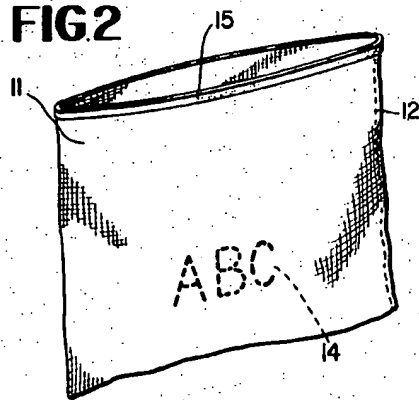
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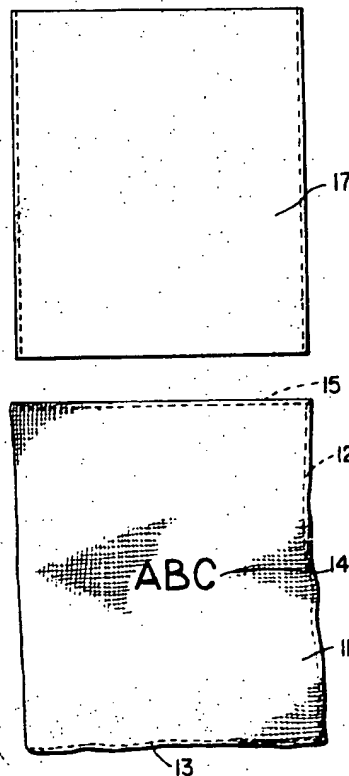
**FIG1**



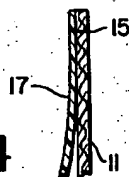
**FIG2**



**FIG3**



**FIG4**



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**METHOD OF MAKING PLASTIC-LINED BURLAP BAG**

This is a division of application Ser. No. 695,645, filed Jan. 4, 1968, now U.S. Pat. No. 3,485,281, issued Dec. 23, 1969.

This invention relates to a plastic lined burlap bag and a method of making the same, and has as its primary object the provision of an improved bag of this nature wherein the liner is loose and free of holes but securely affixed to the top inside rim of the bag only.

An additional object of the invention is the provision of a lined bag of this character wherein the lining is secured, but is at the same time a separate container free of perforations.

A further object of the invention is the provision of a bag of this character wherein the seams are positioned interiorly of the bag and exteriorly of the lining, thus enhancing the appearance of the bag.

A further object of the invention resides in the process of manufacturing the bag and the steps incident thereto wherein the bag may be manufactured and assembled with a minimum of time, effort and difficulty.

Another object is the ensurance of the positive nesting of the liner in every bag.

Still another object of the invention is the provision of a bag of this nature wherein "cuffing" of the liner is obviated, thus effecting a considerable saving in the relatively expensive liner material and labor costs, as well as in the cost of filling.

Other objects will in part be obvious, and in part be pointed out as the description of the invention proceeds, and shown in the accompanying drawings wherein there is disclosed a preferred embodiment of the inventive concept.

In the drawings:

FIG. 1 is a perspective view partially broken away, of a lined bag constructed in accordance with the instant invention.

FIG. 2 is a fragmentary perspective view of the top portion of the bag per se, showing the positioning of adhesive therein prior to turning of the bag and introduction of the liner.

FIG. 3 is an exploded plan view of the bag and liner prior to assembly; and

FIG. 4 is a fragmentary enlarged sectional view taken substantially along the line 4-4 of FIG. 1 as viewed in the direction indicated by the arrows.

Similar reference characters refer to similar parts throughout the several views of the drawings.

Having reference now to the drawings in detail, there is generally indicated at 10 a completed bag constructed in accordance with the instant inventive concept. The bag consists of a burlap or plastic covering 11, which is stitched along one side as at 12, and along the bottom as at 13 to form a unitary open-topped structure. Lettering 14 is applied to the outside of the bag, so as to be readily visible. The seams provided by the stitching 12 and 13 are formed while the bag is inside out, in a manner to be more fully described hereinafter, so that in the finished article the seam is on the inside of the bag.

Prior to assembly a line of thermoplastic adhesive 15 is formed about the inside of the top edge of the bag extending entirely about the periphery thereof, to which is sealed the open top end 16 of a polyethylene or other suitable plastic liner 17. The liner 17 is formed from a tube as a unit, with its bottom edge sealed in the conventional manner. The liner may also be made from sheeting, in which case the bottom and or side may be sealed to form the completed liner. Adhesive 15 is activated after liner 17 has been inserted, to ensure an effective seal of the top edge of the liner to the inside top edge of

the bag, no other connection between the bag and the liner being necessary or desirable. By means of this arrangement the "cuffing" or turning the upper rim of the liner over the upper edge of the bag, as has hitherto been practiced, is obviated, thus providing a quick-opening container easily filled, and effecting a material saving in the amount of relatively expensive polyethylene material required as a liner for each bag.

In the manufacture of the bag a line of preferably thermoplastic adhesive is extruded along one edge of a sheet of burlap or other desired bag material and allowed to harden. The bag is then formed in conventional manner, preferably by suitable machinery, and provided with seams along one side edge and the bottom edge. In manufacture the bag is formed inside out, suitable printing being applied before the stitching operation on what is initially the wrong side of the bag, and the adhesive is then on the outer side. The bag is turned so that the printed matter is on the outside, the liner, also turned inside out, is inserted fully into the turned bag, and the adhesive reactivated. Turning the liner inside out assures positive nesting and freedom from blocking. The top edge of the bag is then pressed firmly into contact with the extruded activated adhesive heated, and is allowed to dry to ensure firm adherence between the top edge of the liner and the top edge of the bag.

If desired, the bag may be made from tubular material in which only the bottom edge need be closed.

Upon completion of the operation there is provided a lined bag with the liner firmly secured only at the inside top edge of the bag, with the seams inside of the bag but exteriorly of the liner, thus enhancing the appearance of the finished article, and with the printing or other indicia on the outside, so as to be readily visible.

From the foregoing it will now be seen that there is herein provided an improved plastic-lined bag and a method of making the same which accomplishes all of the objects of this invention and others, including many advantages of great practical utility and commercial importance.

As many embodiments may be made of this inventive concept, and as many modifications may be made in the embodiment herein shown and described, it is to be understood that all matter herein is to be interpreted merely as illustrative, and not in a limiting sense.

What is claimed is:

1. A method of forming a lined bag which consists of extruding a strip of thermoplastic adhesive along an edge of a piece of bag material, allowing the adhesive to dry, forming a bag with external stitched side and bottom seams with said adhesive strip along the outer edge of the open top, turning the bag to position the seams and the adhesive strip interiorly thereof, inserting an open-topped plastic liner, activating the adhesive by applying heat thereto, and adhering the top outer peripheral edge of the liner to the adhesive strip.

2. The method of claim 1 wherein the bag is formed of burlap.

3. The method of claim 1 wherein the bag is formed of plastic.

4. The method of claim 1 wherein the bag is formed of cotton.

5. The method of claim 1 which includes applying printing to the side of the bag opposite the adhesive strip before forming the seams.

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